



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

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Fax 613 632-5246

D4936-1
Job Sheet 181590



Part No: D4936-1

Job Qty: 12 ea

Part Name: Clamp



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/1/18

Job Tracking No:

Due Date: 8/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV A IPP REV:A NEW ISSUE 13-10-21 JLM VERIFIED BY:DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	12 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Machining-3		
100	Mill Conv	12 pcs	8/10/18	8/10/18	0.00	3.82	Mill Conv 1		
120	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC8		
130	HandFinish	12 pcs	8/10/18	8/10/18	0.00	0.36	HandFinish1		
140	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC7-4		
150	Powdercoat	12 pcs	8/10/18	8/10/18	0.00	0.18	Powdercoat4		
160	QC	12 pcs	8/10/18	8/10/18	0.00	0.00	QC3		
170	Packaging	12 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3-2		
180	QC21-SA	12 Ea	8/10/18	8/10/18	0.00	0.00	QC21		

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.375X0.750	6061T6 Bar .375 X .750	1.8000 ft (.15 ea)	90-Start up Operation	FIN137599-80

12:30pm to 1:00pm 320°F

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.375X0.750	2	27	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Clamp	0.750Inches ± 0.030	0.780 0.720		
2	Clamp	0.380Inches ± 0.030	0.410 0.350		
3	Clamp	1.800Inches ± 0.030	1.830 1.770		
4	Clamp	0.210Inches ± 0.030	0.240 0.180		
5	Clamp	1.375Inches ± 0.010	1.385 1.365		
6	Clamp	0.203Inches + 0.005 - 0.001	0.208 0.202	Diameter	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

7	Clamp	0.900Inches $\pm$ 0.030	0.930 0.870	
8	Clamp	0.030Inches $\pm$ 0.010	0.040 0.020	
9	Clamp	0.250Inches $\pm$ 0.030	0.280 0.220	Radius
10	Clamp	0.060Inches $\pm$ 0.030	0.090 0.030	Radius

Plex 8/1/18 11:40 AM Dart.lajeunesse.marie



Container No: S098321



Part: D4936-1

Job No: 181590

Serial No/Batch: S098321

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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Email: sales@dartaero.com
www.dartaerospace.com

Date: 08/01/18

DQA: _____ Date: _____

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Work Order update only ☐

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